

31/08

Date: Friday, 2/23/2007 1:57:10 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GHW ASSEMBLY	
Job Number	: 30947				
Estimate Number	: 12128				
P.O. Number	: N/A		Part Number	: D412729011	
This Issue	: 2/23/2007	S.O. No. : N/A	Drawing Number	: DSK 092 REV B	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: 28607		Material	: N/A	
Written By			Due Date	: 3/30/2007 Qty: 1 Um: Each	
Checked & Approved By					
Comment	: Est Rev:A 05.01.12 New Issue KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-729-011 CHG003

KS 07.03.05 ①

2.0	30947A	GHW MEDIUM BELL
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3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: Sub-Component GHW MEDIUM BELL	D412-729-041 B	30947A
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6/27/2008 (Dh)



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS	6/27/2008
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6/27/2008



5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-729-011

Location:

PPP Rev: 10

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/08/2008

Job Completion



W/ 07.08.28

Date: Friday, 2/23/2007 1:58:11 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GHW MEDIUM BELL	
Job Number	: 30947A				
Estimate Number	: 12129				
P.O. Number	: N/A	S.O. No.	: N/A	Part Number	: D412729041
This Issue	: 2/23/2007	Type	: MACHINED PARTS	Drawing Number	: DSK 092 REV B
Prsht Rev.	: NC			Project Number	: N/A
First Issue	: N/A			Drawing Revision	: B
Previous Run	: 28607A			Material	: N/A
Written By	:			Due Date	: 3/30/2007
Checked & Approved By	:			Qty:	2
Comment	: Est Rev:E 06.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM		Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL If D412-729-041 is a W/O on its own, Photocopy bluefile and create labels per PPP D412-729-041 CHG003	N/A
2.0	D27287	Decal	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: ✓ Qty Part Number Description Batch 1 D2728-7 Label B22554	
3.0	D3233041	Wheel Assembly	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: ✓ Qty Part Number Description Batch 2 D3233-041 Wheel Assembly B228609	
4.0	D32331	Inside Washer	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: ✓ Qty Part Number Description Batch 2 D3233-1 Inside Washer B228610	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 1:58:11 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 30947A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D32333

Outside Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 D3233-3 Outside Washer B2861-1

PCL 07-08-28

6.0

D33091

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
1 D3309-1 Label B23767

PCL 07-08-28

7.0

D33093

Label



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 D3309-3 Label B23768

PCL 07-08-28

8.0

D3330041

Frame Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 D3330-041 Frame Weldment B30949

PCL 07-08-28

9.0

D3331041

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
1 D3331-041 Handle Assembly B23769B

PCL 07-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 30947A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D3332041

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch
1 D3332-041 Long Pin Assembly 323770

PLOT 08-28

11.0

D3332043

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch
1 D3332-043 Short Pin Assembly 323771

PLOT 08-28

12.0

D33331

Base Plate Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch
1 D3333-1 Base Plate 331522

PLOT 08-28

13.0

D33333

Sliding Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:



Qty Part Number Description Batch
1 D3333-3 Sliding Plate 330951

PLOT 08-28

14.0

D33335

Rail



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:



Qty Part Number Description Batch
4 D3333-5 Rail 328617

PLOT 08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 30947A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D33341

Wheel Shaft



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:



Qty Part Number Description Batch
2 D3334-1 Wheel Shaft 330953

PLOT-08-28

16.0

D33351

Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch
1 D3335-1 Short Spring 322256

PLOT-08-28

17.0

D33353

Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch
1 D3335-3 Long Spring 331931

PLOT-08-28

18.0

D33361

Jack



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty Part Number Description Batch
1 D3336-1 Jack 330954

PLOT-08-28

19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:



Qty Part Number Description Batch
2 AN960JD416 Washer M104215

PLOT-08-28

20.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:



Qty Part Number Description Batch
M16626

PLOT-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 30947A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 CP-21 1/8" Cotter Pin 2" long, Span _____

21.0 HC12 1/4-20 UNC x 1" Hex Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4-20 UNC x 1" long Hex Bolt, Span M16529

Pc 07-08-28

22.0 HC29 5/16-18 UNCx1.5 Hex Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof M103400

Pc 07-08-28

23.0 HC153 3/8"-24UNFx1.25 Hex Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-1533/8"-24 UNF x 1.25" long Hex Bolt, Span M16626

Pc 07-08-28

24.0 HN120 HEX SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-1201" Slotted Nut, Prof M102150

Pc 07-08-28

25.0 HN177 5/16-18UNC Nylon LockNut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-1775/16"-18 UNC Nylon Lock Nut, Span M16999

Pc 07-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 30947A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

HX15

1/4-20 UNCx3/4 S.H.C.S.



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span M16626

PCL 07-08-28

27.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 MS21042L5 Nut (or -5) M104118

PCL 07-08-28

28.0 2333

1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
1 2333 1 1/4" Type B Flat Washer (Wide), Span M102150

PCL 07-08-28

29.0

18SNB

3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
8 18-SNB 3/8" Lock Washer, Span M103717
M114705+4

PCL 07-08-28

30.0

113803

1/8" PTF Grease Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 113-803 1/8" PTF Grease Fitting, Span M102771

PCL 07-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/08/20 _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 30947A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 5/16"WC Type B Flat Washer (Narrow), Prof

m10824

Cpl 07.08.28

32.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Cpl 07.08.28

Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

33.0

QC5

INSPECT WORK TO CURRENT STEP



Jea08.28 (2)

Comment: INSPECT WORK TO CURRENT STEP

34.0

PACKAGING 1

PACKAGING RESOURCE #1



30a47

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

35.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

1/23/08 10:28

Job Completion



U 3/108.28



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE	05.02.18	TITLE HYD. GROUND HANDLING	SCALE 1:5

RELEASED
05/02/22

HEX BOLT 1/4"-20 x 1" LONG (1)
FLAT WASHER 1/4" TYPE B WIDE (1)

D3330-9 TOP PLATE (1)

D3330-5 FRONT PANEL (1)
D3330-7 BACK PANEL (1)
(NOT SHOWN, SIMILAR TO D3330-5)

D3330-15 HANDLE (1)

D3309-3 LABEL (2 PLACES)

D3333-3 SLIDING PLATE (2 PLACES)

D3335-3 LONG SPRING (1)
(NOT SHOWN)

D3330-11 LONG PIN BRACKET (1)

D3332-041 LONG PIN ASS'Y (1)

D3233-1 INSIDE WASHER (2 PLACES)

D3233-3 OUTSIDE WASHER (2 PLACES)

SLOTTED NUT 1"-14 UNF AND
ROUND COTTER PIN 1/8" x 2" LONG
(2 PLACES)

D3334-1 WHEEL SHAFT (2 PLACES)

D3333-5 RAIL (4 PLACES)

HEX. BOLT 3/8"-24 UNF x 1.25" LONG
REG. SPRING LOCK WASHER 3/8"
(8 PLACES)

HEX. BOLT 5/16"-18 UNC x 1.50" LONG
FLAT WASHER TYPE B NARROW 5/16"
STD. HEX. NYLON LOCK NUT 5/16"-18 UNC
(16 PLACES)

GREASE FITTING 1/8" P.T.F.
SAE SPEC. EXTRA SHORT
(4 PLACES)

D3330-17 HANDLE SOCKET (1)

D2728-7 LABEL (1)

D3309-1 LABEL (1)
D3331-041 HANDLE ASS'Y (1)

HEX. SOCKET CAP SCREW
1/4"-20 x 0.75",
AN960JD416
FLAT WASHER (2 PLACES)

D3233-041 WHEEL ASS'Y (2 PLACES)

D3336-1 JACK (1)
D3333-1 BASE PLATE (1)

D3330-19 HANDLE RIM (1)

D3330-3 BOTTOM PANEL (1)

D3330-1 LEFT PANEL (1)

D3330-2 RIGHT PANEL (1)

D3330-13 SHORT PIN BRACKET (1)

D3332-043 SHORT PIN (1)

D3335-1 SHORT SPRING (1)
(NOT SHOWN) SHOP COPY
RETURN TO ENGINEERING

MS21042L5 NUT (2 PLACES) UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NOTE:

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

WORK ORDER
No 30947A